

Work Order ID 76214

76214

Page 1

November-07-11 2:38:06 PM

Item ID: ~~D3200-3~~

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Door Wedge

Start Date: 07/11/2011 Start Qty: 20.00 ✓

20

Cust Item ID:

Required Date: 21/11/2011 Req'd Qty: 20.00

20

Customer:

Reference:

Approvals: Process Plan: M.L.J Date: 11/11/08

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3200

Rev A

100

0.00

100

BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut blank: 1.000 X 1.970"

110

0.00

110

~~HAAS CNC VERTICAL MACHINING #1~~HAAS ~~Peruch~~

Memo

0.00

HAAS CNC vertical machine #1

1-Machine D3200-3 as per Photo FA337 and Dwg D32002-Deburr

issue P/O to Archer. P/O: 15679

machines pending D3200 REV. A

120

0.00

120

QC ~~rec'd~~

Memo

0.00

Quality Control

rec'd + inspect for transit damage
 attache c/c to wp

6/13/12 (20)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 76214

76214

Page 2

November-07-11 2:38:06 PM

Item ID: D3200-3 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Door Wedge
 Start Date: 07/11/2011 Start Qty: 20.00 ***20*** Cust Item ID:
 Required Date: 21/11/2011 Req'd Qty: 20.00 ***20*** Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00		51213/06		counts x76			
140 *140* Packaging Packaging	Identify as per dwg & Stock Location: <u>51.033</u> Memo	0.00 0.00							MF 12-03-06
150 *150* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							12/3/11 [Signature] MF 12-03-06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

November-07-11 2:38:10 PM

76214

D3200-3

Start Date: 07/11/2011

Required Date: 21/11/2011

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP Rev:A Removed from 9 Digit 06-01-25 JLM

MUHMWB10
MIHMWB10
 UHMW 1" Black

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT018	500.2	
117321	74.6	
117738	124.3	
117819	99.3	
119145	202	
ST	39.3	
118814	39.3	

5 ~~9/10~~ 11/12/13

D 3200-3 P

X 20

$4\frac{1}{2}/3\frac{1}{2}$ (20)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

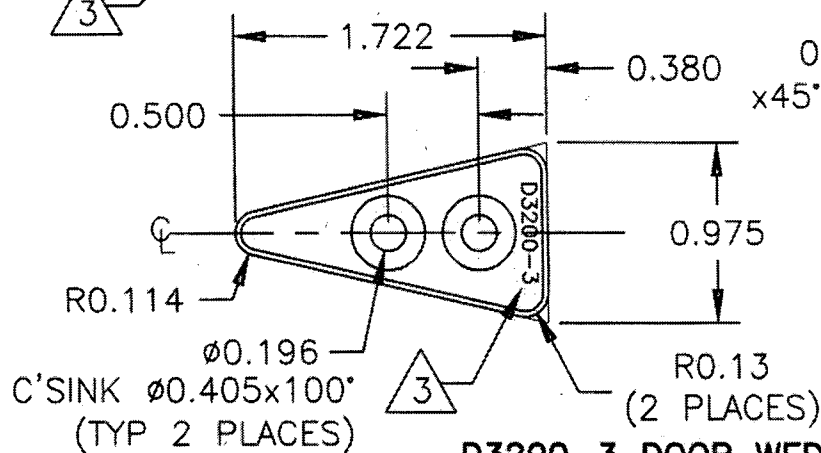
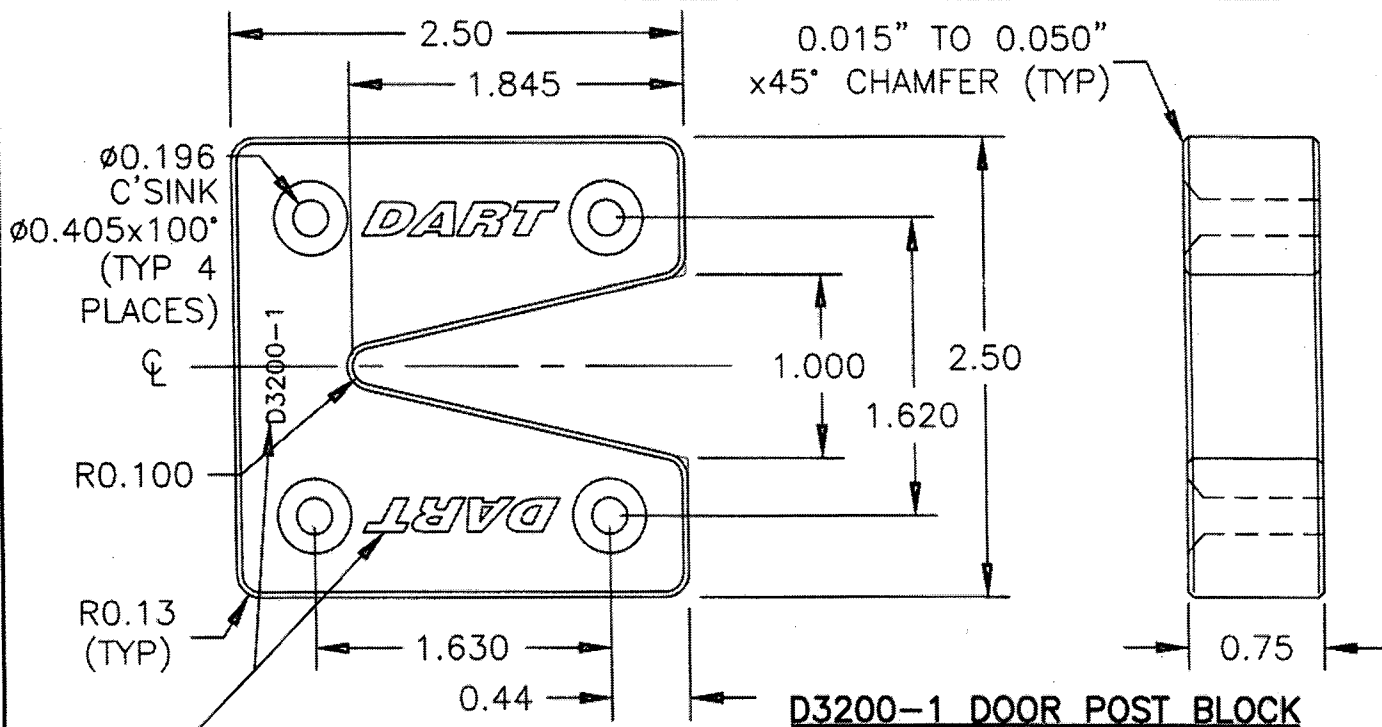
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN	UP	DRAWN BY	UP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	#	APPROVED	#	DRAWING NO. D3200	REV. A SHEET 1 OF 1
DATE	03.08.06			TITLE DOOR WEDGE	SCALE 1:1
A	03.08.06			NEW ISSUE	



RELEASED
03.09.02

SHOP COPY
RETURN
ENCLOSURE
SUBMITTAL
WORK ORDER
NO. 762114

D3200-1/-3

- 1) MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689
- 2) PARTS ARE SYMMETRIC ABOUT CENTERLINE
- 3) ENGRAVE DART LOGO AND P/N IN AREAS SHOWN
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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1393 Major Road
Orleans, ON
K1E 1H3

Phone # 613-899-2405

Packing Slip

Date	Invoice #
2/29/2012	65

Ship To
Main Finished Goods Location Dart Aerospace 1270 Aberdeen Street Hawksbury, Ontario K6A 1K7

P.O. No.	Ship	Via	FOB	Project
15679	2/29/2012	FedEx	Archer	

Qty	Item Code	Description
20 Sales 7 Sales		D3200-3P item 5 on PO# 15679 D3640-1P item 8 on PO# 15679 HST (ON) on sales



1393 Major Road
Orleans, Ontario
K1E 1H3

Telephone (613) 899-2405
Fax (613) 226-1719


Certificate of Compliance

To:
Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury Ont.
K6A 1K7

8-7/63/64

Po Number	Part Number	Quantities
15679	D3200-3P	20
	D3640-1P	7

It is hereby certified that all articles mentioned above are in conformance with the requirements, specification and drawings as listed on customer purchase order number, 15679 issued by Dart Aerospace Inc.


Alex Mazerolle
President
Archer Precision Inc.
1393 Major Road,
Orleans Ontario
K1E 1H3



Inspection Report

Customer Name Dart Aerospace	QTY 20	DWG # D3200-3	REV. 	Part Name Door Wedge	Date Feb 29/2012	Lot# 	Job # 477-5
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Page 1 of ____	Inspection Interval 	Special Notes
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Item #	DWG. Dim	Tolerance	Operator First Off	QA First Off		QA Final		4	8	12	16	20
				A	R	A	R					
	Rev			✓		✓						
	MAT	supplied	UHMV	✓		✓						
	SUB	no		✓		✓						
	Deburr	.005/.010		✓		✓						
1	.500	+/- .005	.500	✓		✓						
2	1.722	+/- .005	1.722	✓		✓		1.723	1.722	1.721	1.721	1.721
3	.380	+/- .005	.381	✓		✓						
4	.975	+/- .005	P.P.	✓		✓						
5	R.13	+/- .010	.125	✓		✓						
6	2X		✓	✓		✓						
7	Engraving		OK	✓		✓		✓	✓	✓	✓	✓
8	Ø.196	+/- .005	.195	✓		✓		.195	.195	.195	.195	.195
9	Ø.405	+/- .005	.407	✓		✓		.407	.407	.407	.407	.407
10	100°		100°	✓		✓						
11	2X		✓	✓		✓						
12	R.114	+/- .005	P.P.	✓		✓						
13	.015	+/- .005	.0107	✓		✓						
14	.050	+/- .005	.040	✓		✓						
15	45°		✓	✓		✓						
16	.75	+/- .010	.7495	✓		✓		.749	.749	.749	.749	.749



Inspection Report

Customer Name Dart Aerospace		QTY 7	DWG # D3640-1	REV. A	Part Name Belt Guide		Date Feb 29/2012	Lot#	Job # 477-8		
Page 1 of ____		Inspection Interval		Special Notes							
Item #	DWG. Dim	Tolerance	Operator First Off	QA First Off A R	QA Final A R	2	3	4	5	6	7
	Rev		A	✓	✓						
	MAT	supplied	Delrin	✓	✓						
	SUB	no		✓	✓						
	Deburr	.005/.010	✓	✓	✓						
1	4.50	+/- .010	4.500	✓	✓	4.498	4.498	4.498	4.500	4.500	4.500
2	.40	+/- .010	.40	✓	✓						
3	2X		✓	✓	✓						
4	.200	+/- .005	.201	✓	✓	.201	.201	.201	.201	.201	.201
5	2X		✓	✓	✓						
6	.31	+/- .010	.310	✓	✓						
7	2X		✓	✓	✓						
8	.13	+/- .010	.130	✓	✓						
9	2X		✓	✓	✓						
10	Engraving		OK	✓	✓	✓	✓	✓	✓	✓	✓
11	.80	+/- .010	.7995	✓	✓	.7995	.7995	.7995	.7995	.7995	.7995
12	.23	+/- .010	.230	✓	✓	.230	.230	.230	.230	.230	.230
13	.40	+/- .010	.400	✓	✓	.400	.400	.400	.400	.400	.400
14	R.13	+/- .010	.125	✓	✓						
15	.625	+/- .005	.623	✓	✓	.623	.623	.623	.623	.623	.623
16	.03	+/- .010	.030	✓	✓						
17	45°		✓	✓	✓						

Date of Issue July, 13, 2005.